

Work Order ID 58789

Wednesday, May 19, 2010 9:16:34 AM



Page 1

Item ID: D350-600-241

Accept



Setup Start



Revision ID:

Item Name: Spacepod, LH, AS350

Stop



Start Date: 5/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: 10-5-9 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D350-600-241
CHG 001

8/10/08/13

Handwritten: BG 10-9-13

110

0.00



Small Fab

Small Fab

Memo

0.00

1-Drill holes in D3188-1 using drill jig Dt8970
2-Open holes in D3188-1 body floor to 0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-1 as per dwg D3188

Handwritten: 2T 10-09-07

120

QC5- Inspect part completeness to step on W/O

0.00



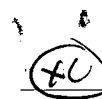
QC

Quality Control

Memo

0.00

Handwritten: 5/10/08/08



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y

1-drill and plug section I-I and J-J of dwg D3188 p. 11 using Hysol 934NA with milled glass fibres 10% to weight

A/R Hysol batch: 115222

xpiry date: 11-07-16

A/R Milled fibers batch: 100859

2-Attach Neoprene Foam using Contact cement

A/R Contact cement Batch: _____

NA as per B# 31835

25 10-09-07

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S1062100

CC

W/O:		WORK ORDER CHANGES					
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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>115028</u> Memo	0.00 0.00							
180  QC Quality Control	QC3- Inspect Part Finish Memo Stores #185 Pick Kit	0.00 0.00							BR 10-9-10 10/19/13 Pto →
190  QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							8.10/09/13

Dart Aerospace Ltd

W/O: 58789		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/09/08	# 185	Perm. change ADD step for picking kit. Also adjust sep #3	SD MA	10/9/13 10.09.16			S 10/09/08

Part No: D350-600-241 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-600-141 Location: <u>118</u> PPP rev: <u>B</u>								
210	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

mf
10-9-25

W/O:		WORK ORDER CHANGES					
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IPP rev B 07.04.16 reformat,D3188 revE ec IPP Rev:C
remove D3188-1m add D3188-5 DD 10.04.07 verified by:JLM IPP rev D
10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified

Start Qty: 1.00

Required Qty: 1.00

D3188-5 Manufactured No 110 Each 0.0000 1



Spacepod Body

D3186-3 Manufactured No 110 Each 1.0000 1



Spacepod Door, LH

D3187-1 Manufactured No 110 Each 1.0000 1



Spacepod Floor

ALS4-1032-130 Purchased No 110 Each 2,223.000 28



Insert

Location

Loc Qty

Loc Code

CA

1

52522

1

Location

Loc Qty

Loc Code

ST241B

1

31835

1

Location

Loc Qty

Loc Code

ST282

446

110511

38

114407

408

ST381

1777

114654

1777

B 58900

B 58909

m 114723 x 2%

ST 10-08-30

ST 10-08-30

ST 10-08-08

X1

ST 10-08-07

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Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

A3235-020-935 Purchased No 110 Each 556.0000 8



Washer - Countersunk

Location Loc Qty Loc Code
 ST281 556

106150

556

X8

D2986-1 Manufactured No 150 Each 4.0000 1



Rubber Spacer

Location Loc Qty Loc Code
 ST242 4

57659

4

D3015-3 Manufactured No 150 Each 187.0000 1



Locknut

Location Loc Qty Loc Code
 ST033 187

43758

26

56701

3

58202

158

X1

D3554-7 Manufactured No 150 Each 36.0000 1



Ball Stud

Location Loc Qty Loc Code
 ST070 36

37674

36

X1

BT 10-09-07

BT 10-09-07

BT 10-09-07

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Start Qty: 1.00

Required Qty: 1.00

D3567-1 Manufactured No 150 Each 14.0000 1



Decal



ST 10-09-07

Location

Loc Qty

Loc Code

ST070

14

48254

14

AN960JD516

NAS1149D05635

Purchased No

150

Each

0.0000

1



Washer

D2237

Manufactured No

150

Each

99.0000

2



Striker Plate



ST 10-09-07

ST 10-09-07

Location

Loc Qty

Loc Code

ST009

99

57255

40

58181

59

MS20426AD4-5

Purchased No

150

Each

6,056.000

4



Rivet



ST 10-09-07

Location

Loc Qty

Loc Code

ST317

6056

6733

1074

6874

4982

X4

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Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

D3538-1 Manufactured No 150 Each 22.0000 2



Hinge Bracket



RT 10-09-07

Location	Loc Qty	Loc Code
ST069	22	
55012	10	
56531	12	

x2

D2179 Manufactured No 150 Each 53.0000 2



Doubler



RT 10-09-07

Location	Loc Qty	Loc Code
ST007	53	
35432	53	

x2

AN526C832R24 Purchased No 150 Each 64.0000 4



screw



RT 10-09-07

Location	Loc Qty	Loc Code
ST327	64	
110179	64	

x4

MS27039-08-11 Purchased No 150 Each 89.0000 2



Screw



RT 10-09-07

Location	Loc Qty	Loc Code
ST288	50	
114382	50	
ST290	39	
113749	39	

x2

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Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 *NAS 1149DN 8325* Purchased No 150 Each 0.0000 20



Washer

NAS1515H3

Purchased No 150 Each 142.0000 2



Washer

Location

Loc Qty

Loc Code

ST277

142

111268

142

MS21042L08

Purchased No 150 Each 383.0000 18



Nut

m 115016 x 18

Location

Loc Qty

Loc Code

ST300

383

114330

383

D2464

Manufactured No 150 f 369.1934 11.34



3/4 Seal

Location

Loc Qty

Loc Code

ST402

369.1934

48173

369.1934

x 11.34

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Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

D2586 Manufactured No 150 Each 129.0000 2



Door Latch



ET 10-09-07

Location Loc Qty Loc Code

ST006 100

57917 100

ST204 29

55314 29

x2

D2585 Manufactured No 150 Each 52.0000 2



Mounting Channel



ET 10-09-07

Location Loc Qty Loc Code

ST018 14

55313 14

ST019 38

56524 38

D2621 Manufactured No 150 Each 93.0000 2



Latch Plate, 350 Spacepod



ET 10-09-07

Location Loc Qty Loc Code

ST021 93

46842 24

56526 69

x2

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Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15 Purchased No 150 Each 171.0000 2



Screw



10-09-07

Location Loc Qty Loc Code

ST292 171

114056 71

114718 100

AN960JD10 Purchased No 150 Each 0.0000 2



Washer

115107



10-09-07

MS21042L3 Purchased No 150 Each 1,918.000 2



Nut

114784



10-09-07

Location Loc Qty Loc Code

ST300 1918

113537 20

113644 398

114523 1000

114718 500

D2857-1 Manufactured No 150 Each 23.0000 1



Hinge Bracket



10-07-07

Location Loc Qty Loc Code

ST026 23

55019 4

56529 19

10-07-07

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Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

D2857-2 Manufactured No 150 Each 33.0000 1



Hinge Bracket



ET 10-09-07

Location	Loc Qty	Loc Code
ST027	33	
55020	13	
56530	20	

X1

D2228 Manufactured No 150 Each 46.0000 4



Bracket Plate



ET 10-09-07

Location	Loc Qty	Loc Code
ST009	46	
48228	46	

X4

AN526C832R10 Purchased No 150 Each 195.0000 10



Screw



ET 10-09-07

Location	Loc Qty	Loc Code
ST327	195	
104603	3	
113154	100	
113288	42	
114382	50	

X10

D3557-1 Manufactured No 150 Each 15.0000 1



Bracket



ET 10-09-07

Location	Loc Qty	Loc Code
ST070	15	
50283	15	

X1

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Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

AN526C832R14

Purchased

No

150

Each

746.0000

2



Screw

A



RT 10-09-07

Location

Loc Qty

Loc Code

ST327

746

104916

746

x2

K10021

Manufactured

No

190

Each

0.0000

1



Spacepod Hardware Kit (-241)

D350-600-449

Manufactured

No

190

Each

0.0000

1



Switch Relocation

D2985

Manufactured

No

190

Each

11.0000

1



Label

Location

Loc Qty

Loc Code

ST032

11

48236

1

50232

10

1

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GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58289

BS-0-5-19

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F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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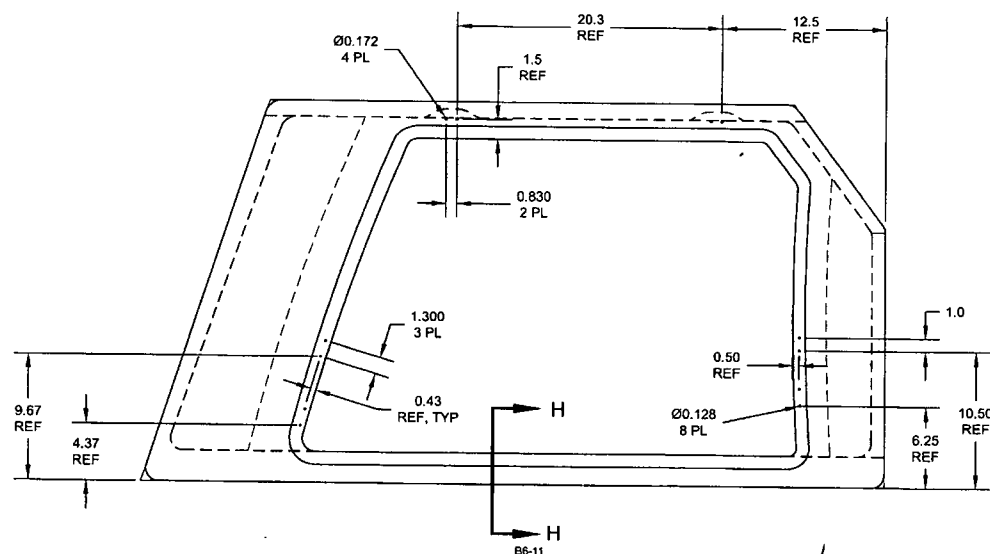
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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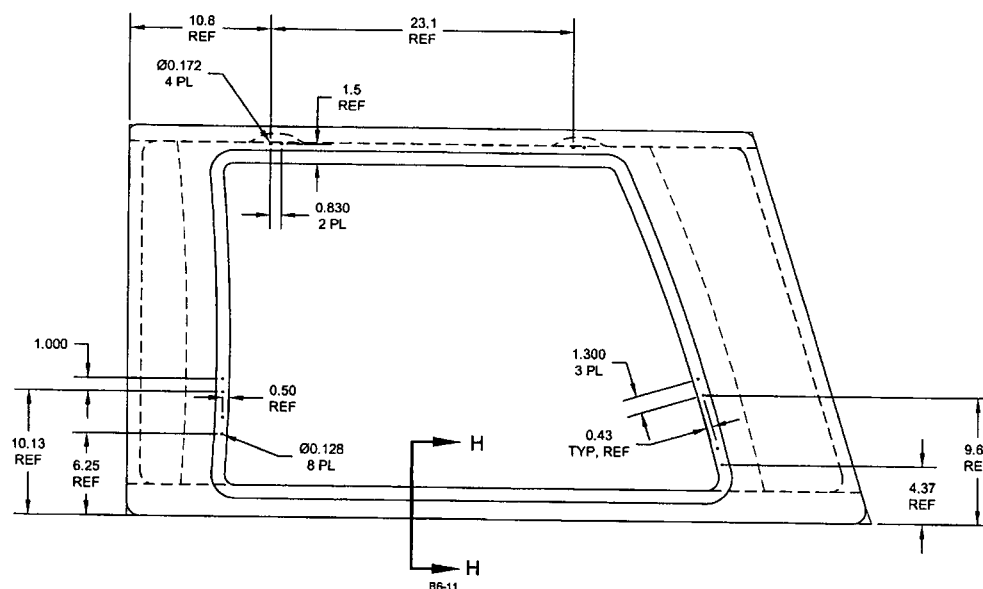
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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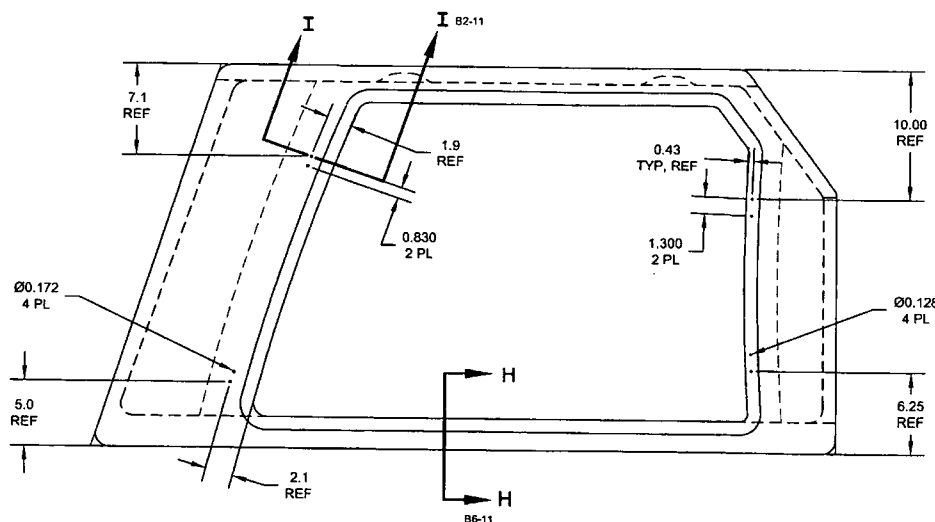
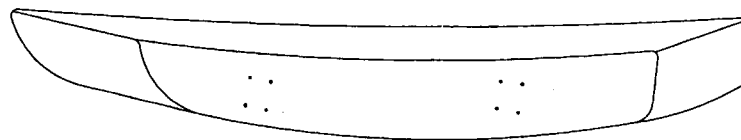
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

W/0 58789

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- NOTES:**
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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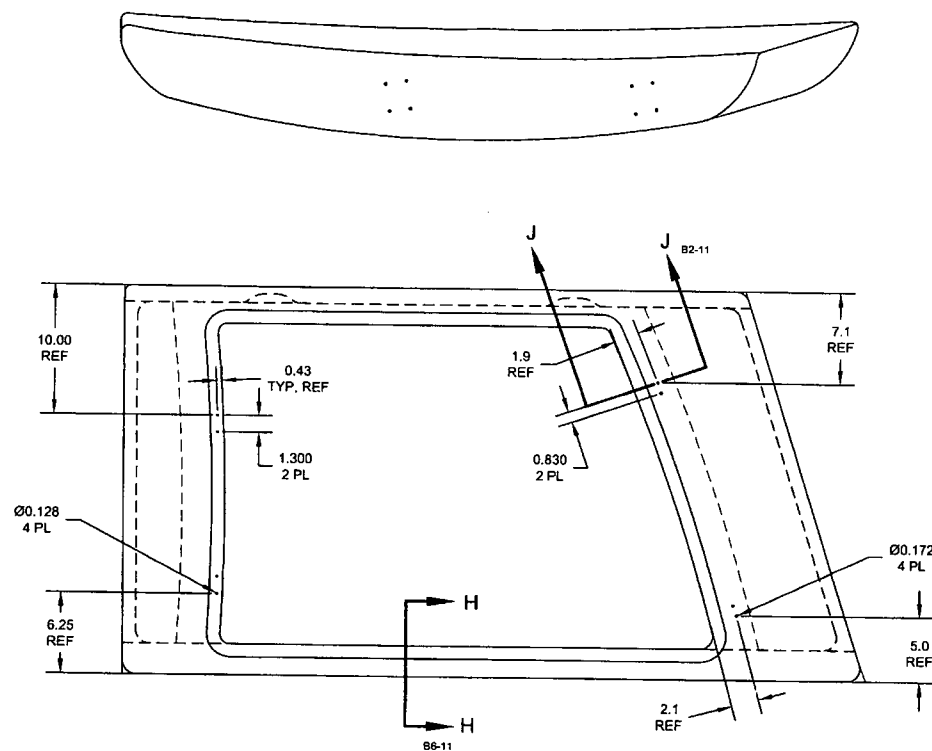
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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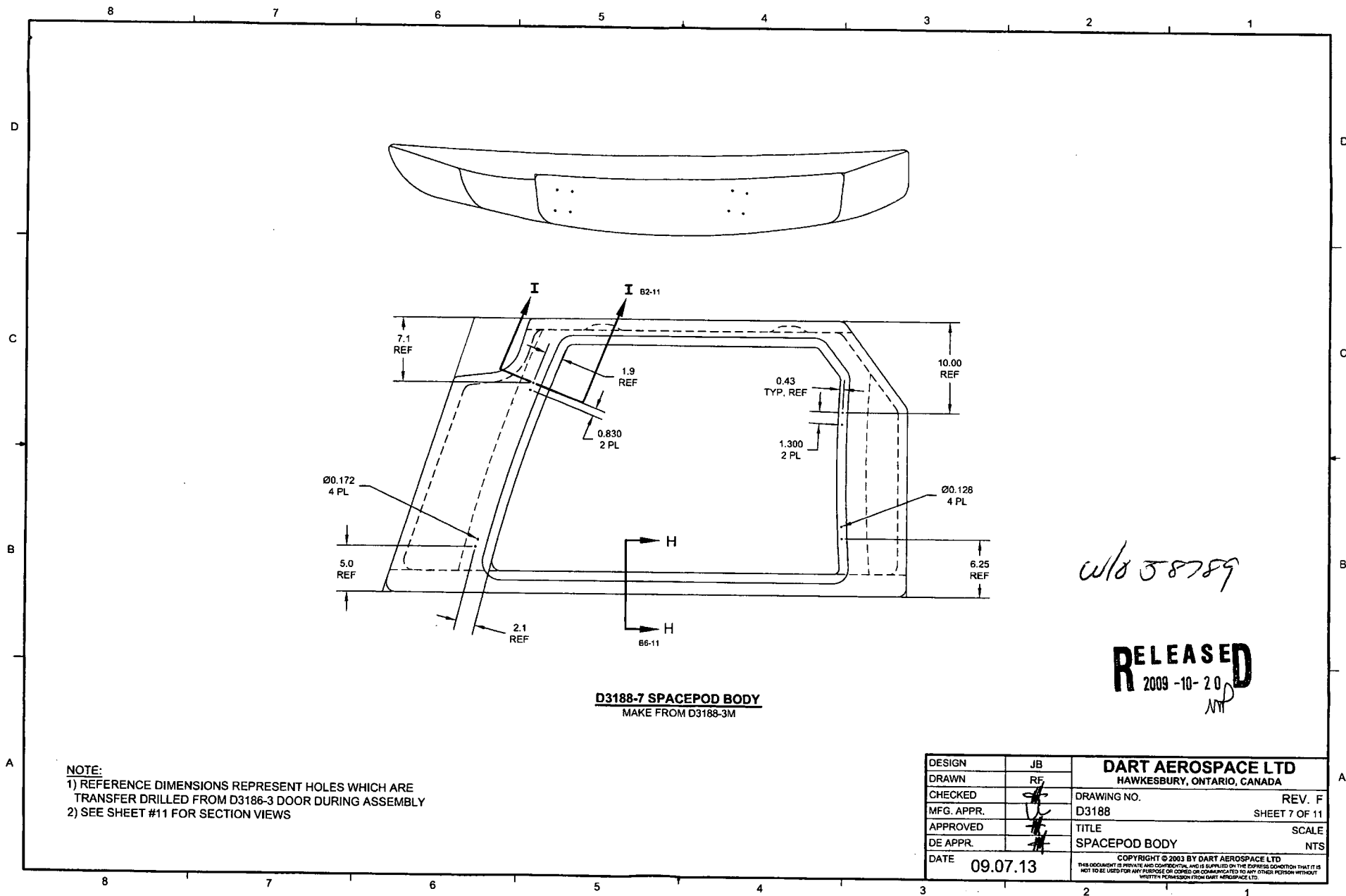
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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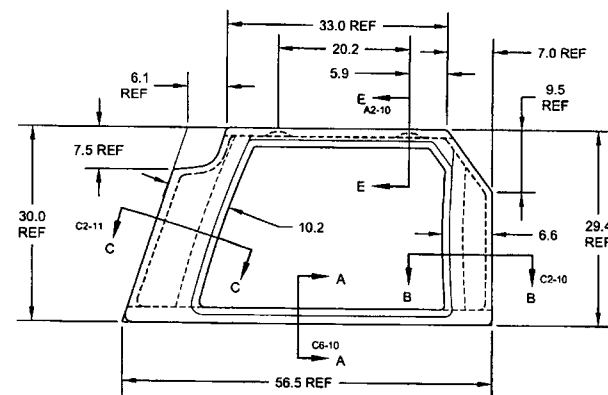
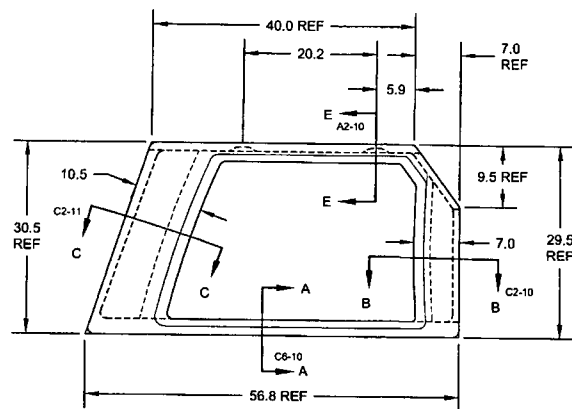
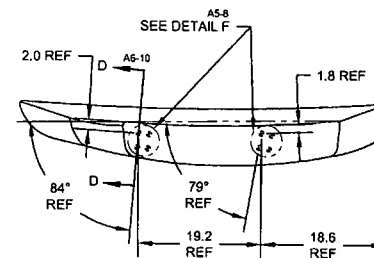
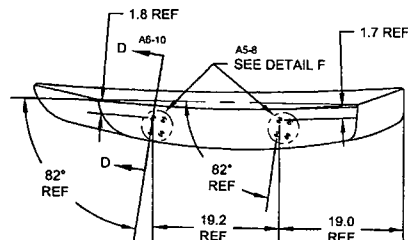
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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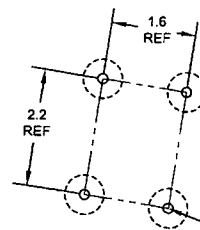
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3186-1M SPACEPOD BODY

D3186-3M SPACEPOD BODY



DETAIL F





INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A5-10

D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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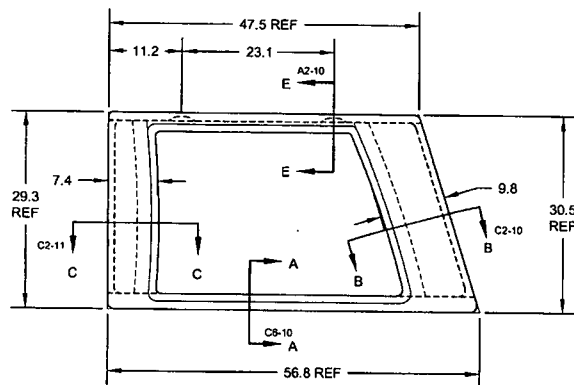
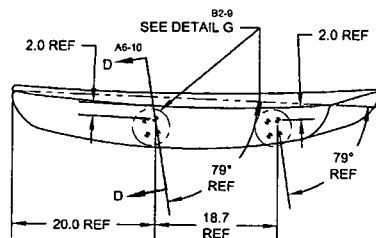
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

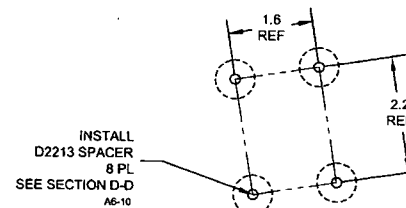
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-2M SPACEPOD BODY







DETAIL G D6-9

W/8 58789

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D3188-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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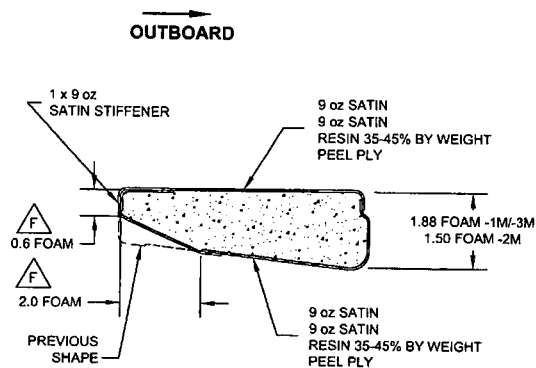
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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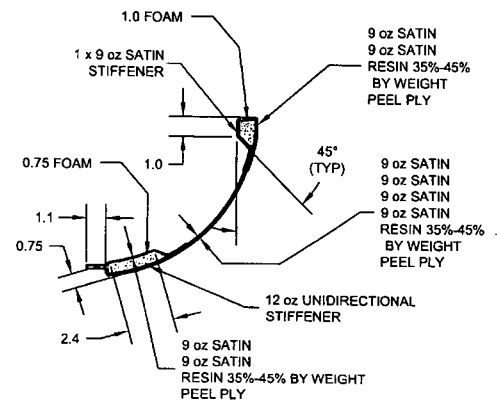
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



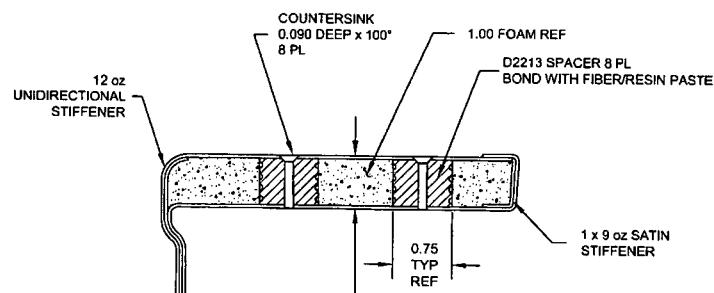
SECTION A-A
TYPICAL FLOOR SECTION

B7-B
B3-B
B6-B



SECTION B-B
SECTION C-C OPPOSITE

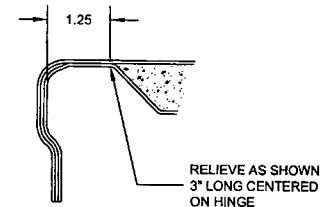
B6-B
B8-B
B4-B
B2-B
B7-B
B5-B



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS

D3-B
D7-B
D6-B

9 oz SATIN
9 oz SATIN
18 oz CLOTH
1.00 FOAM
9 oz SATIN
9 oz SATIN
RESIN 35-45% BY WEIGHT
PEEL PLY



SECTION E-E
2 PLACES PER POD

C2-B
C7-B
B6-B

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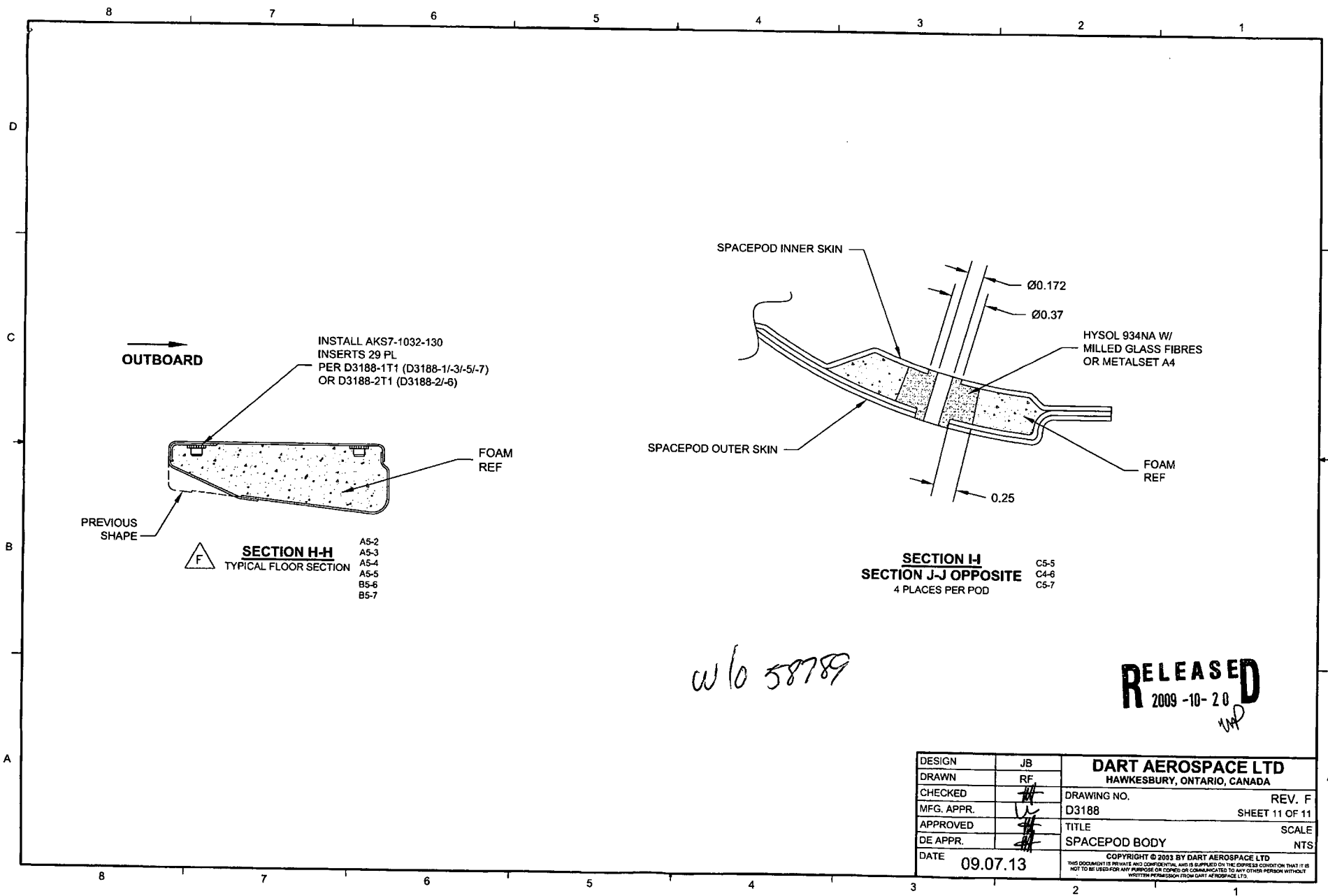
W/O:		WORK ORDER CHANGES					
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